

**Work Order ID 50098**

Page 1

July 08, 2009 11:13:41 AM

Item ID: D3145-2

Accept

Setup Start

Revision ID: B

Stop

Item Name: Bracket

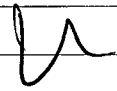
Start Date: 7/10/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3145	Rev B								

100

0.00

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

 09/07/1010 0

110

0.00

HAAS CNC VERTICAL MACHINING #1

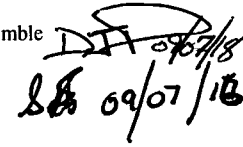
HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per Folio FA318 and Dwg D3145 Deburr and Tumble

 09/07/1010 0

120

0.00

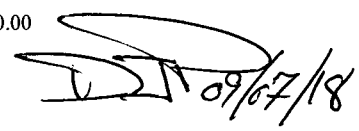
QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

 09/07/1010 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50098

July 08, 2009 11:13:41 AM

Page 2

Item ID: D3145-2 Accept Setup Start  
Revision ID: B Stop  
Item Name: Bracket  
Start Date: 7/10/2009 Start Qty: 10.00 Cust Item ID:  
Required Date: 7/31/2009 Req'd Qty: 10.00 Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00	amf 09/07/20			10	10		
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00	UMD 09/07/20			(x10)			
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:20 320° FINISH TIME: 9:50		OVEN TEMPERATURE: 16K 09-07-21			(10)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 50098**

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July 08, 2009 11:13:41 AM

**Item ID:** D3145-2 **Accept** **Setup** **Start**  
**Revision ID:** B **Stop**  
**Item Name:** Bracket  
**Start Date:** 7/10/2009 **Start Qty:** 10.00 **Cust Item ID:**  
**Required Date:** 7/31/2009 **Req'd Qty:** 10.00 **Customer:**  
**Reference:**

**Approvals:** **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run** **Start**  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
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QC	Memo	0.00	2>	502/2/21		410	φ		
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Quality Control

170	Identify as per dwg & Stock Location: <u>67</u>	0.00							
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Packaging	Memo	0.00							
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Packaging

180	QC21- Final Inspection - Work Order Release	0.00							
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QC	Memo	0.00							
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Quality Control

9/7/21 100 Sep

09/07/22

MF 09-0722

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

July 08, 2009 11:13:41 AM

Work Order ID: 50098

Parent Item: D3145-2RevB

Parent Item Name: Bracket

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	30.0000	4.0347			

6061-T6 Bar 2.00 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

30

110167

2.36

13085

12

17124

15.64

17124

4.0347

and 07/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

50098A

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 50097
<b>Description:</b> BRACKET		<b>Part Number:</b> D3145-2
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>

**FIRST ARTICLE INSPECTION CHECKLIST**
☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.240	$\pm 0.010$	0.245	✓			
Ro.250	$\pm 0.010$	0.250	✓			(2PLCS)
0.180	$\pm 0.010$	0.1815	✓			
1.250	$\pm 0.010$	1.250	✓			
1.960	$\pm 0.010$	1.963	✓			
$\phi.221 \times 0.351$	$\pm 0.010 / \pm 0.010$	0.218 x 0.344	✓			Slot
28.9°	$\pm 1/2^\circ$	28.9°	✓			
0.108	$\pm 0.010$	0.110	✓			
Ro.330	$\pm 0.010$	0.330	✓			
Ro.188	$\pm 0.010$	0.1875	✓			TYP
0.125	$\pm 0.010$	0.131	✓			TYP
1.636	$\pm 0.010$	1.637	✓			REF
95°	$\pm 1/2^\circ$	95°	✓			
0.125	$\pm 0.010$	0.125	✓			
0.219	$\pm 0.010$	0.210	✓			
Ro.125	$\pm 0.010$	0.125	✓			
Ro.387	$\pm 0.010$	0.387	✓			
0.766	$\pm 0.010$	0.766	✓			REF
0.250	$\pm 0.010$	0.252	✓			
1.370	$\pm 0.010$	1.370	✓			
0.760	$\pm 0.010$	0.760	✓			
4.303	$\pm 0.010$	4.303	✓			REF

<b>Measured by:</b> JJJ	<b>Audited by:</b> JJJ	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/07/14	<b>Date:</b> 09/07/20	<b>Date:</b>	N/A

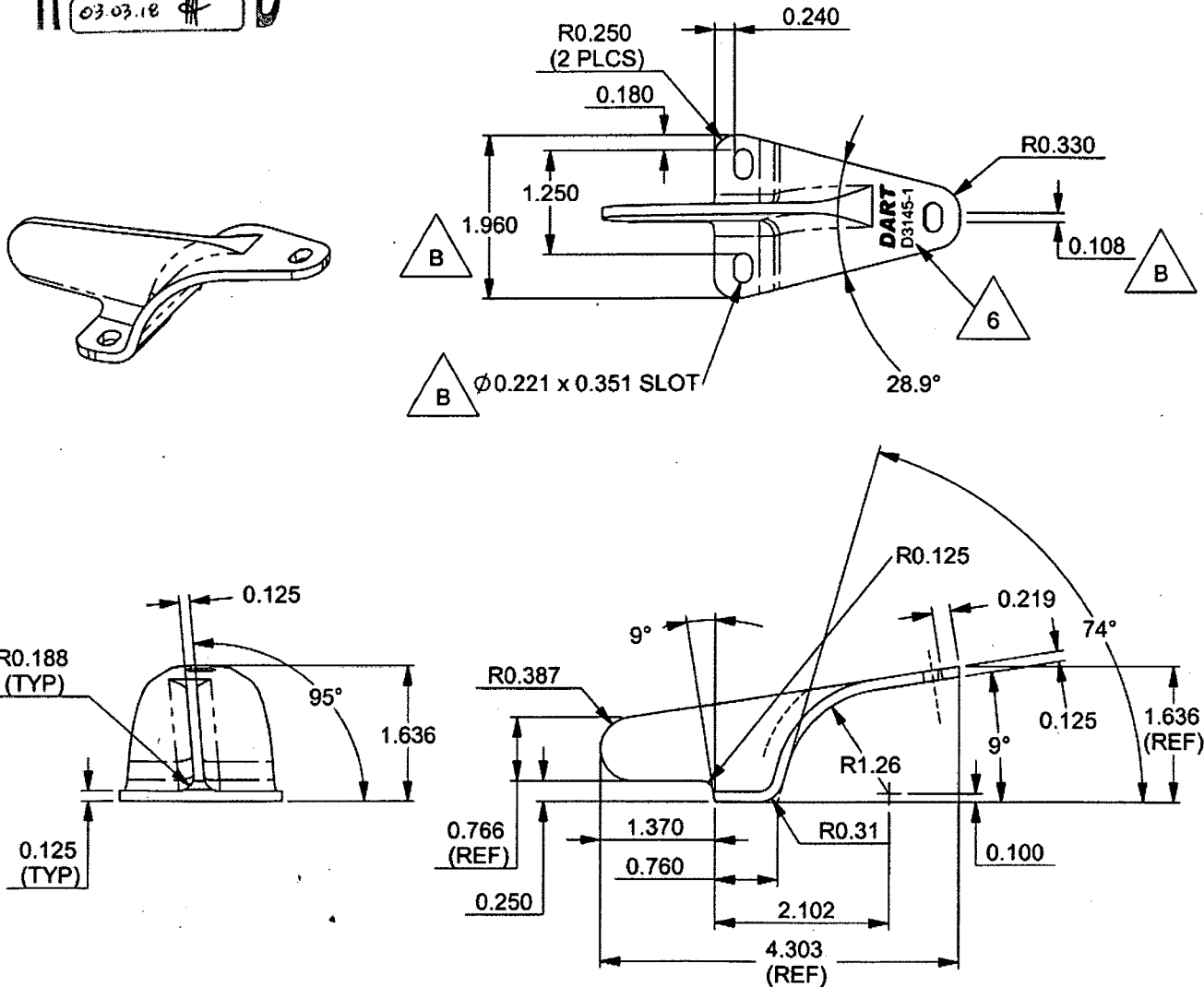
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	

Same as w/o 50097

**DART**

DESIGN <i>RT</i>	DRAWN BY <i>UP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3145</b>	REV. B SHEET 1 OF 1
DATE <b>03.02.06</b>		TITLE <b>BRACKET</b>	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

**RELEASED**  
03.03.18



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25  
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries